

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008620**Date Inspected:** 12-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Chen, Tu Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG & Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

TRIAL ASSEMBLY YARD

This QA Inspector randomly observed the following work in progress.

OBG SEGMENT-1AAE-1AE

FCAW welding process of weld joint 44 located on PCMK SP406-001. Welder is identified as 045880 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 42 located on PCMK SP407-001. Welder is identified as 058245 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 44 located on PCMK SP402-001. Welder is identified as 062708ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

FCAW welding process of weld joint 42 located on PCMK SP401-001. Welder is identified as 045276 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2132.

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SMAW welding process of weld joint 852 located on PCMK SEG2E. Welder is identified as 068764 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

SMAW welding process of weld joint 891 located on PCMK SEG2E. Welder is identified as 067665 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-P-2114-FCM-1.

SMAW welding process of weld joint 003 located on PCMK OBE1A. Welder is identified as 058242 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

SMAW welding process of weld joint 002 located on PCMK OBE1A. Welder is identified as 058242 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

SMAW welding process of weld joint 001 located on PCMK OBE1A. Welder is identified as 066413 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

OBG SEGMENT-1AAW-1AW

FCAW welding process of weld joint 558 located on PCMK SEG1E. Welder is identified as 058174 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

FCAW welding process of weld joint 548 located on PCMK SEG1E. Welder is identified as 220066 ZPMC QC is identified as Chen Bo. The welding variables recorded by QC appeared to comply with the WPS-B-T-2233-B-U3-F.

OBG SEGMENT-2AW-2BW

This Q.A Inspector observed ZPMC performing weld repair (rounding welding) on the weld joint between ‘T’ stiffeners to bottom panel at PP13. Welder is identified as 220067 ZPMC QC is identified as Chen Bo. The welding variable recorded by QC appeared to comply with the WPS -345-SMAW-2G (2F) Repair.

OBG SEGMENT-3AE-3BE

This QA Inspector observed sandblasting in progress in OBG segment 3AE-3BE.

BAY#10

FCAW welding process of weld joint 65 located on PCMK NSD1-A166H/J. Welder is identified as 057266 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the

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WPS-B-T-4333-TC-P4-F.

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversation

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Simonis - 134-7246-3441, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
